

# Work Order ID 81227

**\*81227\***

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March-12-12 12:36:59 PM

Item ID: D206-642-211

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube LH

Start Date: 12/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 26/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/12 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D206-642

O

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP206-642-211 CHG006

110

Pick Kit

0.00

**\*110\***

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

**\*120\***

QC

Memo

0.00

Quality Control

**B76975**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 81227

**\*81227\***

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March-12-12 12:36:59 PM

Item ID: D206-642-211

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube LH

Start Date: 12/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 26/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00

**\*130\***

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-211 Location: 82

Rev F

IX SP 12-04-10

140

0.00

**\*140\***

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

12/4/12

MF 12-04-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 81227

\*81227\*

Parent Item: D206-642-211

\*D206-642-211\*

Parent Item Name: Skidtube LH

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J04.08.06Revised Step 4 per CHG003KJ/JLMJ04.08.06  
IPP Rev:K 07-12-04 ECN 1080p DD verified by: IPP rev L  
10.02.02 per IIN rev M EC verified by: JLM IPP REV:M 11.11.17  
PER IIN REVO DD VERF;EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D206-642-241

Manufactured

No

110

Each

0.0000

1

1

\*D206-642-241\*

Replacement Skidtube

D206-651-041

Manufactured

No

110

Each

11.0000

1

1

\*D206-651-041\*

206A/B GHW

Location

Loc Qty

Loc Code

FG120

11

79558

11

110

Each

6.0000

2

2

D2665-1

Manufactured

No

\*D2665-1\*

Saddle, LH Fwd Aft Out 206

Location

Loc Qty

Loc Code

ST436

6

52306

6

110

Each

12.0000

2

2

D2666-1

Manufactured

No

\*D2666-1\*

Saddle, LH Fwd Aft In 206

Location

Loc Qty

Loc Code

ST426

12

55018

6

60296

2

60870

4

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 81227

**\*81227\***

Parent Item: D206-642-211

**\*D206-642-211\***

Parent Item Name: Skidtube LH

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-41A

Purchased

No

110

Each

475.0000

8

8

\*\*

**\*AN3-41A\***

Bolt

Location

Loc Qty

Loc Code

ST335

275

120644

275

8

ST354

200

120498

200

Manufactured

No

110

Each

855.0000

16

16

\*\*

D2652

**\*D2652\***

Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST013

811

73834

15

73836

36

76134

1

76135

19

76136

55

77134

400

77136

285

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 81227

Parent Item: D206-642-211

Parent Item Name: Skidtube LH

\*81227\*

\*D206-642-211\*

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

3,226.000

8

\*MS21042L3\*

Nut

\*\*

M121162sf

L

## Location

## Loc Qty

## Loc Code

ST300

3226

117441

16

117885

32

118451

5

118927

3

119017

2990

119075

180

AN960JD10

NAS1149D0363J

Purchased

No

110

Each

0.0000

8

\*AN960JD10\*

Washer

\*\*

M120644sf

L

AN5-7A

Purchased

No

110

Each

2,697.000

4

\*AN5-7A\*

Bolt

\*\*

sf

L

## Location

## Loc Qty

## Loc Code

ST337

2697

119017

2697

110

Each

753.0000

4

AN5-11A

Purchased

No

\*AN5-11A\*

Bolt

\*\*

sf

L

## Location

## Loc Qty

## Loc Code

ST337

753

118191

13

119512

740

110

Each

0.0000

8

AN960JD516

NAS1149D0563J

Purchased

No

\*AN960JD516\*

Washer

\*\*

M118614 12/4/12sf

L

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 81227

\*81227\*

Parent Item: D206-642-211

\*D206-642-211\*

Parent Item Name: Skidtube LH

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN4-6A

Purchased

No

110

Each

1,745.000

12 12

\*\*

\*AN4-6A\*  
Bolt

Location

Loc Qty

Loc Code

ST356

1745

119017

1745

110

Each

14.0000

24 24

\*\*

AN960JD416

NAS1149D0463J

Purchased

No

\*AN960JD416\*  
Washer

Location

Loc Qty

Loc Code

ST351

14

116289

14

110

Each

3,831.000

12 12

\*\*

MS21042L4

\*MS21042L4\*  
Nut

Location

Loc Qty

Loc Code

ST300

3831

117441

51

117601

157

118451

133

119017

200

119075

3290

110

Each

107.0000

12 2

\*\*

AN6-44A

\*AN6-44A\*  
Bolt

Location

Loc Qty

Loc Code

ST343

7

119127

7

st510

100

119036

100

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 81227

**\*81227\***

Parent Item: D206-642-211

**\*D206-642-211\***

Parent Item Name: Skidtube LH

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L6

Purchased

No

110

Each

934.0000

2 2

**\*MS21042L6\***

Nut

\*\*

## Location

## Loc Qty

## Loc Code

ST300

934

117677

25

118384

3

118927

48

119075

658

120308

200

AN960JD616

NAS1149D0663J

Purchased

No

110

Each

0.0000

4 4

**\*AN960JD616\***

Washer

\*\*

AN4C5A

Purchased

No

110

Each

269.0000

1 1

**\*AN4C5A\***

BOLT

\*\*

## Location

## Loc Qty

## Loc Code

ST355

269

112243

169

119017

100

AN960C416

NAS1149C0463

Purchased

No

110

Each

0.0000

1 1

**\*AN960C416\***

washer

\*\*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

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Work Order ID: 81227

**\*81227\***

Parent Item: D206-642-211

**\*D206-642-211\***

Parent Item Name: Skidtube LH

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Manufactured No

110

Each

79.0000

\*\*

**\*D3413-1\***

Ring

Location

Loc Qty

Loc Code

ST420

21

70773

1

79233

20

ST464

58

76754

34

77940

2

80224

22

D2712

Manufactured No

110

Each

832.0000

\*\*

**\*D2712\***

Set Screw

Location

Loc Qty

Loc Code

FG

50

29962

50

ST017

500

79585

500

ST021

282

76065

282

D2884

Manufactured No

110

Each

125.0000

\*\*

**\*D2884\***

Saddle Spacer

Location

Loc Qty

Loc Code

FG

10

29453

10

ST020

115

76751

115

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 81227

\*81227\*

Parent Item: D206-642-211

\*D206-642-211\*

Parent Item Name: Skidtube LH

Start Date: 12/03/2012

Required Date: 26/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2885

Manufactured No

110

Each

116.0000

2

2

\*D2885\*

Saddle Spacer

\*\*

12/4/12

Location

Loc Qty

Loc Code

FG

10

29199

10

ST020

106

76752

106

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 4.3 206A/B HIGH GEAR SKIDTUBES

ITEM	QTY -211	QTY -212	QTY -213	QTY -214	QTY -241	QTY -247	PART NUMBER	DESCRIPTION
	X						D206-642-211	SKIDTUBE INSTALLATION, LH
		X					D206-642-212	SKIDTUBE INSTALLATION, RH
			X				D206-642-213	SKIDTUBE INSTALLATION, LH, THRU BOLT
				X			D206-642-214	SKIDTUBE INSTALLATION, RH, THRU BOLT
1	1	1	1	1	X		D206-642-241	SKIDTUBE
						X	D206-642-247	WEARSHOE KIT (REPLACES -243)
	1	1	1	1			D206-651-041	* 206 GHW ADAPTER <sup>(1)</sup>
1					1		D2650-3	SKIDTUBE ASSEMBLY
2A					18		D2651-1	* PLUG <sup>(1)</sup>
2B					18		D2651-3	* O-RING <sup>(1)</sup>
3					1		D2646	* AFT CAP <sup>(1)</sup>
4					2		MS27039-1-08	* SCREW <sup>(1)</sup>
5					2		NAS1149D0332J	* WASHER <sup>(1)</sup> (OR AN960JD10L)
6	1		1				D2665-1	SADDLE, FWD OUT, LH
6		1		1			D2665-2	SADDLE, FWD OUT, RH
7	1		1				D2666-1	SADDLE, FWD IN, LH
7		1		1			D2666-2	SADDLE, FWD IN, RH
8	1						D2665-1	SADDLE, AFT OUT, LH
8		1					D2665-2	SADDLE, AFT OUT, RH
8			1				D2667-1	SADDLE, AFT OUT, LH
8				1			D2667-2	SADDLE, AFT OUT RH
9	1						D2666-1	SADDLE, AFT IN, LH
9		1					D2666-2	SADDLE, AFT IN, RH
9			1				D2668-1	SADDLE, AFT IN, LH
9				1			D2668-2	SADDLE, AFT IN, RH
10	8	8	8	8			AN3-41A	BOLT
11	16	16	16	16			D2652	BUSHING
12A	8	8	8	8			MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8			NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4			AN5-7A	BOLT
14	4	4	4	4			AN5-11A	BOLT
14A			2	2			AN5-32A	* BOLT <sup>(2)</sup>
14B			2	2			MS21042-5	* NUT (OR MS21042L5) <sup>(2)</sup>
15	8	8	8	8			NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12			AN4-6A	BOLT
17	24	24	24	24			NAS1149D0463J	* WASHER (OR AN960JD416)
18	12	12	12	12			MS21042-4	NUT (OR MS21042L4)
20A					4	4	D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1	D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1	D3535-13	WEARSHOE (REPLACES D2656-13)
22B					1	1	D3536-13	GASKET
23A					1	1	D3535-21	WEARSHOE (REPLACES D2656-21)
23B					1	1	D3536-21	GASKET
24A					1	1	D3535-33	WEARSHOE (REPLACES D2656-33)
24B					1	1	D3536-33	GASKET
26A					44	44	MS27039C1-08	SCREW
26B					44	44	NAS1149C0332R	WASHER (OR AN960C10L)
26C					44		ALS7-1032-130	* INSERT <sup>(1)</sup> (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
28	2	2	2	2			AN6-44A	BOLT
29A	2	2	2	2			MS21042-6	NUT (OR MS21042L6)
29B	4	4	4	4			NAS1149D0663J	* WASHER (OR AN960JD616)
34	1	1	1	1			AN4C5A	BOLT
35	1	1	1	1			NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1			D3413-1	RING (REPLACES D2655)
37	10	10	5	5			D2712	SET SCREW
38	2	2	2	2			D2884	SADDLE SPACER
39	2	2	2	2			D2885	SADDLE SPACER

NOTES: <sup>(1)</sup> DENOTES THAT PART IS INCLUDED WITH D2650-3 ASSEMBLY ABOVE<sup>(2)</sup> MAY BE REQUIRED ON -213/-214 INSTALLATIONS<sup>(3)</sup> NOT INSTALLED AS PART OF SKIDTUBE. USED TO MODIFY OEM GROUND HANDLING WHEELS

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Revision: 0

Date: 11.06.15